Work Orde		0		*98	510*						Page 1
Revision ID:	D3255-1			Accept	*N9()(	<b>1</b> 040	100	)* s	etup Star Stop	I VI	S1* S2*
Start Date:	3/11/13	Start Qty: 4.00	*4*		Cust Item	ID:					
Required Date:	3/19/13 <b>I</b>	Req'd Qty: 4.00	*4*		Custome	r:					
Reference:								_			
Approvals:	Process Plan:		Date; 13-03-1	2 Tooling:		Date:		K	tun Star	!/	R1*
·			_ Date:	SPC (Y/N):		Date:			Stop	` *N	R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisi	on Nbr									
D3255	Rev B	:								ŧ.	
*100	F	LOW WATER JET		0.00				4	۵		Jm 13-4-
Waterjet		Memo		0.00	0 .						
FLOW CNC Waterj	et	l-Cut as pe Deburr if n	er Dwg D3255 Dwg Re ecessary	ev: <b>_b</b> Prog Rev:	<u>D</u> 2-	•					
110	Ç	C2- Inspect parts off r	machine FAI/FAIB	0.00							
*11 <b>0</b> *		Memo		0.00				4			Jm13-4-9
Quality Control											
					Ş						
120	. (	QC8- Inspect parts - sec	cond check	0.00	7			1.1			
*120*				<b>り</b>	49			<u> </u>			
$\Omega$ C		3.6		0.00	-						

Quality Control

											DQA:	Date	:
NCR: Y	⁄es	/ No				WORK ORDER NON-C	100	NFORM	ANCE / UP	DATE			4
											QA Closed:	Date	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	- No	-				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in	Crimped it n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ш	Torque W	raves in E	xtrusio	n L	Drawing	<u> </u>	Jout of (	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Packaging

												DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE				•	
		·							·			QA Closed:	Dat	te:	
Work Ord	er.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
WOIK OIG	٠,٠.					Rework	]		Skid-tube	Crosstube		]	Water Jet		Engineering
Part I	No.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•					Use-as-is	]	Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR I	۱o. <sub>-</sub>	· · · · · · · · · · · · · · · · · · ·	<del></del>	<del></del>		Work Order Update	]		Large Fab	Composite		]	Supplier		
Root					Descri	tion of work order update		Initial	Ac	ction		Sign &	-		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	1	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material	Ш				)										•
Setup				ļ											
Other		i													
Process	Ш						l								
Supplier															
Training							l		,						
Unapproved							L								
							AUI	LT CATE	GORY						
Landi		i				General	_	7		ı		1	· r		
	-	Bending				Bend	<u> </u>	Grain				Ovalized			Pressure/Forced
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route	<u> </u>	Hardwa				Over/Under	į.	-	Temperature/Cure
	$\vdash$	Cracks			<u> </u>	Broken/Damaged	<u> </u>	4 '	on Incomplete			Part Incorred		_	Weld
	-	Crushed/	Crimped		ļ	Burrs	Ŀ	1	ions Incomplete/	/Unclear		Part Lost/Mi	ssing [		Wrong Stock Pulled
	$\vdash$	Cuffs			<u> </u>	Contamination	<u></u>	Mainte				Part Moved			
	-	Heat Trea			<u> </u>	Countersink	<u></u>	Mislabe				Positioned V	- r	_	
	-	Inspection		Tube		Cut Too Short	<u></u>	Misread	j	į		Power Loss/	Surge [		Other
	$\vdash$	Ripples in			<u> </u>	Drill Holes	$\vdash$	Offset						-	
l	'	Torque W	laves in E	xtrusio	n	Drawing	1	Out of 0	Calibration						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde March-12-13 1:		510		*985	510*					Page 3
Item ID: Revision ID: Item Name:	D3255-1			Accept	*N900	<b>040</b>	100	)* s	etup Star Stoj	111.71
Start Date: Required Date: Reference:	3/11/13 3/19/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:			. Cu	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	27 11 11 11 11 11	ate: ate:		F	tun Star Sto <sub>l</sub>	"NR I"
Sequence ID/ Work Center II 160 *160* QC Quality Control		Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp

										DQA:	Date:	
NCR:	res / No				WORK ORDER NON-O	100	VFOR	MANCE / UPDA	TE			
										QA Closed:	Date:	
Work Orde	ar.				DISPOSITION				AGAINST DEF	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update			Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Ī	nitial	Action	1	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											·	
Operator												
Material												
Setup												
Other		ļ	ļ									
Process						1						
Supplier												
Training												
Unapproved		<u> </u>	<u> </u>									
					F	AUL	T CATE	GORY				
Landi	ng Gear			· ·	General		-					-
	Bending				Bend	L	Grain			Ovalized		Pressure/Forced
	Centre N	Not Conce	ntric to	o/s	_BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct	Weld
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/Uncl	lear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			Γ	Contamination		Mainte	enance		Part Moved		
!	Heat Tre	eat		·	Countersink		Mislabe	eled		Positioned V	Vrong_	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# Picklist Print

March-12-13 1:58:01 PM

Work Order ID:

98510

Parent Item:

D3255-1

Parent Item Name:

Panel

**Start Date: 3/11/13** 

Required Date: 3/19/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	221.2600	1.484	6.2484212 6.5			Jm13-4
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				MAT020		221.26				<del> </del>			
				1182	271	10.76							
				120	366	55.6							
				1213	389	154.9			<u> 197</u>	<u>889</u>			

												DQA:	Da	te:	
NCR:	⁄es	/ No				WORK ORDER NON-C	O	VFOR	MANCE / UP	DATE		•			<u> </u>
									· · · · · · · · · · · · · · · · · · ·			QA Closed:	Da	te:	
Work Orde	or.				,	DISPOSITION				AGAINST	DE	PARTMENT	PROCESS .		
WOIK OIG	-' .				·············	Rework	1 <b>1</b>		Skid-tube	Crosstube	Γ	]	Water Jet	Г	Engineering
Part N	٧o.		•			Scrap	1 1		Machining	Small Fab	-	Proc	d. Eng. Coor.	_	Quality
	•			<u></u>		Use-as-is	1	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	۷o.					Work Order Update			Large Fab	Composite		]	Supplier		
													· · ·		
Root	1		1		1	ption of work order update	1	nitial	1	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling						•	İ					,			,
Operator															
Material			l												
Setup												i l			
Other				<u> </u>											
Process	Ш														
Supplier			ļ												
Training															
Unapproved						# # U.S.									
						F.	AUL	T CATE	GORY						
Landi	ng (	Gear				General		•	`			_	,		•
		Bending				Bend		Grain				Ovalized		L	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	are			Over/Under	tolerance	_	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete			Part Incorrec	:t		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order:	98510
Description: Access Panel Assembly	Part Number:	D3255-1
Inspection Dwg: D3255 Rev: B		Page 1 of 1

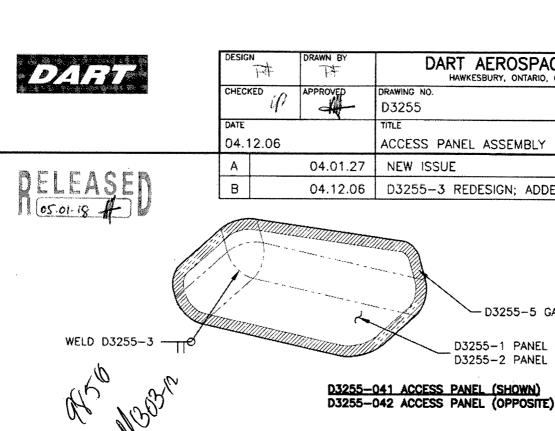
## FIRST ARTICLE INSPECTION CHECKLIST

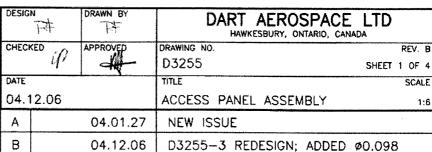
Х	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098"	L		V	Itmos
15.171	+/-0.010	15,171"	_		T	Ikmolo
10.032	+/-0.010	10.035	~		V	Jkmolo Produsoz
6.902	+/-0.010	6.902	7		V	
18.456	+/-0.010	18.4562	_		T	
11.432	+/-0.010	11.432"	r	·	V	
	:					
					•	·
-						,

		*	OPG		
Measured by:	In	Audited by:	27	Prototype Approval:	N/A
Date:	13-4-9	Date:	13.49	Date:	N/A

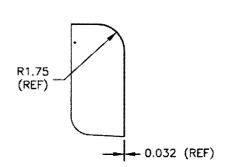
Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM	

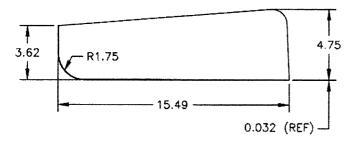




- D3255-5 GASKET D3255-1 PANEL (SHOWN) D3255-2 PANEL (OPPOSITE)

R1.75 7.50 6.87





#### D3255-1 BEND DETAIL D3255-2 OPPOSITE

D3255-041/-042 NOTES:
1) WELD PER DART QSI 004

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

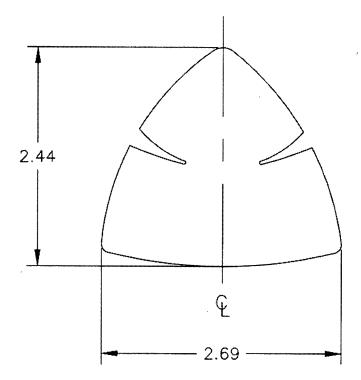
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED (	APPROVED	DRAWING NO. D3255	REV. B SHEET 2 OF 4	
DATE		TITLE	SCALE	
04.12.06		TITLE	1:1	





98510

<u>D3255-3 CAP</u> FORM TO FIT D3155-1/-2

## D3255-3 NOTES:

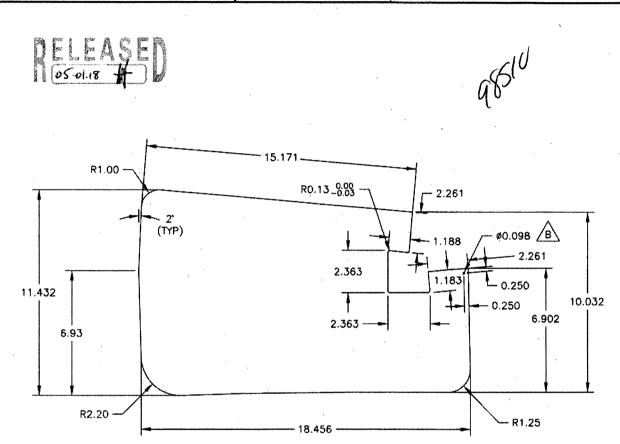
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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CHECKED	APPROVED	DRAWING NO. D3255	SHEET	REV. 3 OF	_
DATE		TITLE	<del>4</del>	SCA	LE
04.12.06		ACCESS PANEL ASSEMBLY		1	1:5



### D3255-1/-2 FLAT PATTERN

## D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
  2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

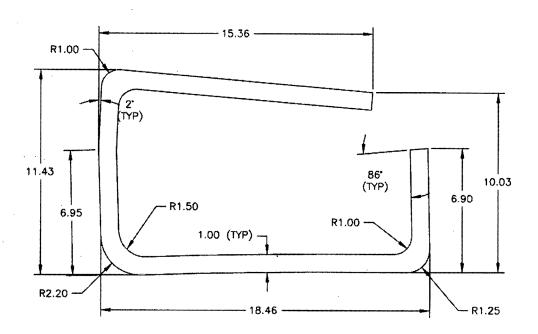
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DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





#### D3255-5 GASKET

- D3255-5 NOTES:
  1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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